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D2519
Job Sheet 183782



Part No: D2519

Job Qty: 40 ea

Part Name: Clamp



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/26/18

Job Tracking No:

Due Date: 10/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP: B 00.03.16 Re-format, laser cutting EC IPP REV:C 11.10.05 MADE IN HOUSE DD
VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea	10/12/18	10/12/18	0.00	0.00	Start Up Waterjet		DL 18/09/18
100	Waterjet - B4B	40 pcs	10/12/18	10/12/18	0.00	1.37	Waterjet1		DL 18/09/18
120	QC	40 pcs	10/12/18	10/12/18	0.00	0.00	QC8		SEP 27 2018 68
130	Brake NC	40 pcs	10/12/18	10/12/18	0.02	1.97	Brake NC 1		SAB DAS
140	QC	40 pcs	10/12/18	10/12/18	0.00	0.00	QC5		DAS NOV 19 2018 68
150	Packaging	40 pcs	10/12/18	10/12/18	0.00	0.00	Packaging3	57542	6 NOV 19 2018 8-89
160	QC21-SA	40 Ea	10/12/18	10/12/18	0.00	0.00	QC21		9-89

Part Op 100 - 1-Cut as per Dwg
Descriptions: 130 - 1- remove press and machine marking as necessary

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	1.9800 sf (.0495 ea)	90-Start up Operation	5106172

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S16GA	2	276	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp	0.257inches + 0.006 - 0.001	0.263 0.256		
2	Clamp	0.400inches ± 0.030	0.430 0.370		
3	Clamp	0.750inches ± 0.010	0.760 0.740		
4	Clamp	8.561inches ± 0.010	8.571 8.551		
5	Clamp	0.063inches ± 0.010	0.073 0.053		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐	QTY Effective : _____ MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____
Deviation			
1210 PUGHILL, SUITE 100 NEWBURY, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 09/27/18 Container No: S114037 Part: D2519 Job No: 183782 Serial No/Batch: S114037 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's			
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : _____			